

Work Order ID 68658

Tuesday, April 19, 2011 3:14:02 PM



Page 1

Item ID: D3281-2L08

Revision ID:

Item Name: Floor Protector, Fwd RH

Start Date: 4/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:



Date: 11/04/19 Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3281

DEQ-E-1

100



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

X

SL
11/04/26

Thermoforming Machine

Cut Blanks

105



Dry Material

0.00

X

SL
11/04/26

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 340°F

Time IN: 4:30 AM

11/04/25

Time OUT: 7:00 AM

11/04/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68658

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Page 2

Item ID: D3281-2L08

Accept



Setup Start



Revision ID:

Item Name: Floor Protector, Fwd RH

Stop



Start Date: 4/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110



THERMOFORMING MACHINE

0.00

x2

Jh

Thermoform

Thermoforming Machine

Memo

0.00

Thermoform as per Dwg. D3281 and Folio FTA 008

Dwg. Rev. FFolio Rev. D

16/04/26

120



QC2- Inspect parts off machine FAI/FAIB

0.00

x2

Jh

QC

Quality Control

Memo

0.00

16/04/26

130



HAND FINISHING THERMOFORMING

0.00

x2

JL

Thermoform

Thermoforming Machine

Memo

0.00

Trim to Finished Dimensions

16/04/26

W/O:		WORK ORDER CHANGES					
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Work Order ID 68658

Tuesday, April 19, 2011 3:14:02 PM



Page 3

Item ID: D3281-2L08

Accept



Setup Start



Revision ID:

Item Name: Floor Protector, Fwd RH

Stop



Start Date: 4/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

x2

D
11/04/2011

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8 11/04/2011

(8)

160



Packaging

Packaging

0.00

Memo

0.00

11/4/28

(2) S

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 68658

Tuesday, April 19, 2011 3:14:02 PM

Page 4

Item ID: D3281-2L08

Accept



Setup

Start



Revision ID:

Item Name: Floor Protector, Fwd RH

Stop



Start Date: 4/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 19, 2011 3:14:09 PM

Page 1

Work Order ID: 68658



Parent Item: D3281-2L08



Parent Item Name: Floor Protector, Fwd RH

Start Date: 4/19/2011

Required Date: 4/21/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A 10.02.24 New Issue LL
Add Step 105 Dry Material 10/04/21 DL

IPP REv. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	2,284.710	5	10.52632			

Lexan Sheet



Location	Loc Qty	Loc Code
therm	2284.71	
	2284.71	

113127

10.52632 sf ft

Wh
10/04/27

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	G9658
Description: Floor Protector, Fwd RH	Part Number:	D3281-2
Inspection Dwg: D3281 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than .1875" Go/No Go	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by

104

Date:

11/04/20

TRIMMING SECTION

Measured by:

2

Date:

11/04/2022

Audited by:

七

Date:

11/04/22

Preliminary Approval:

N/A

Date:

NA

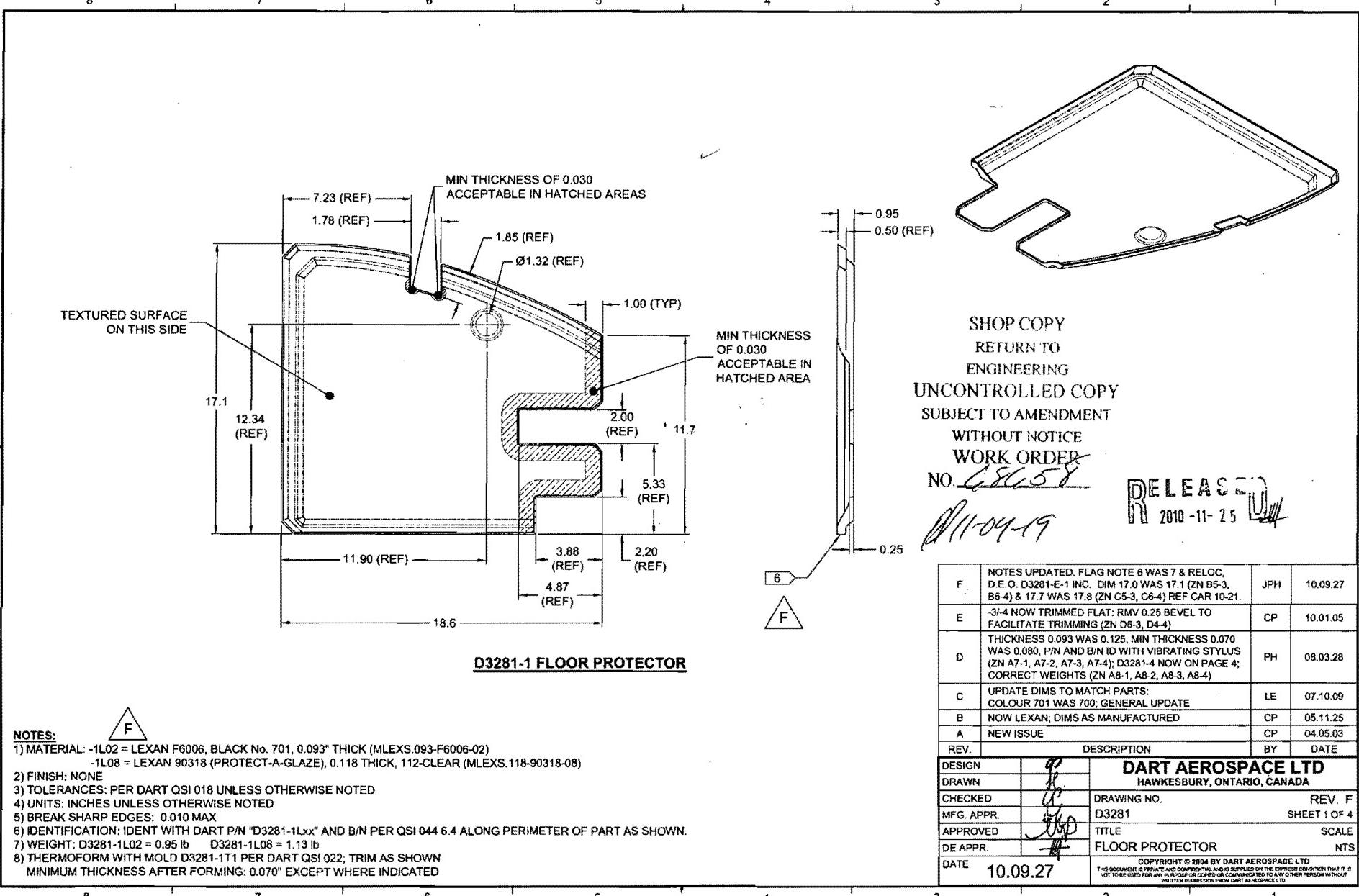
Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	08.07.23	Dwg Rev updated	KJ/DL	
D	08.09.12	Tolerance revised for 0.070 dimension	KJ/DL	
E	10.09.01	Dwg Rev updated	KJ	✓

W/O:		WORK ORDER CHANGES					
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

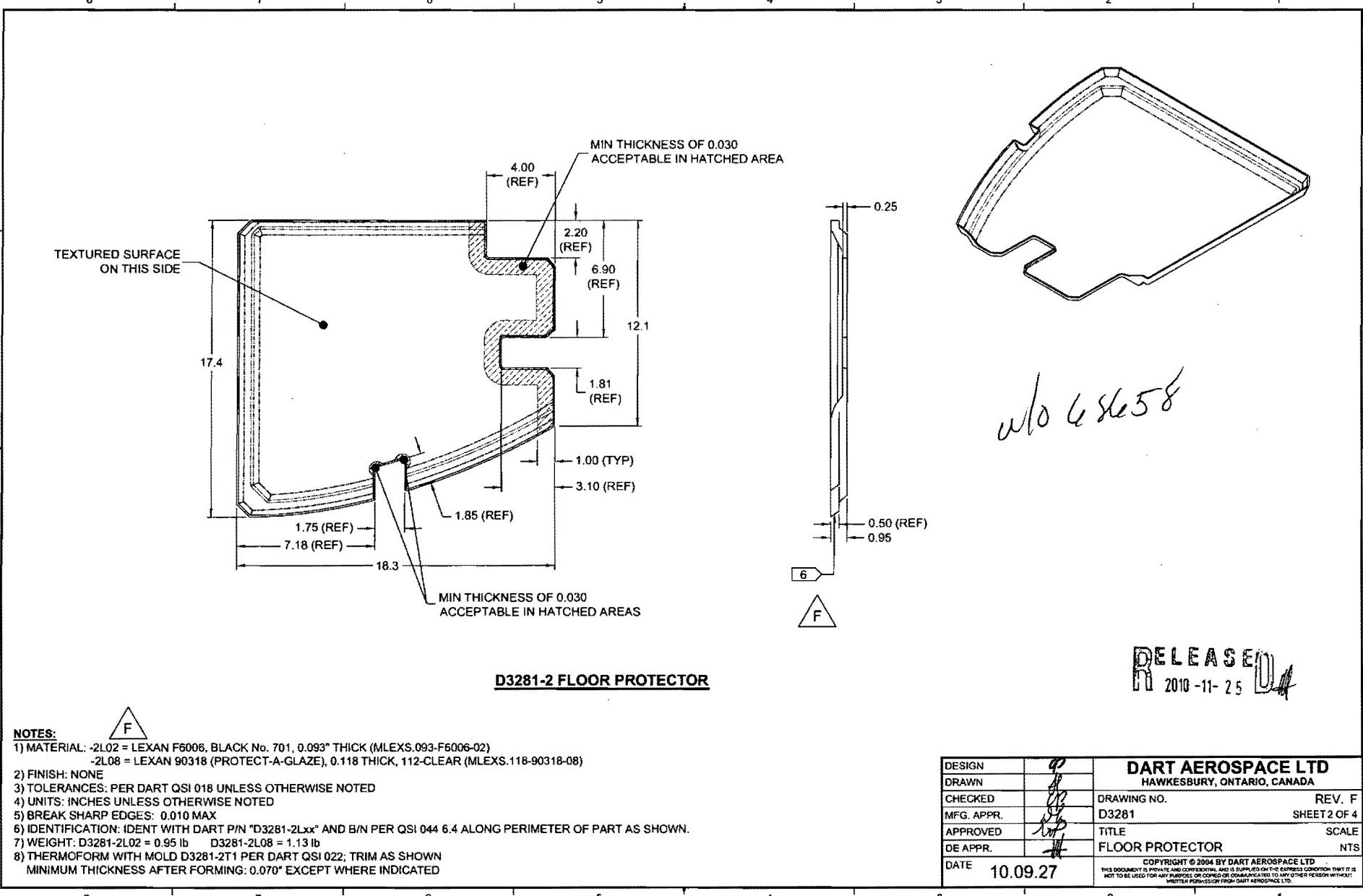


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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

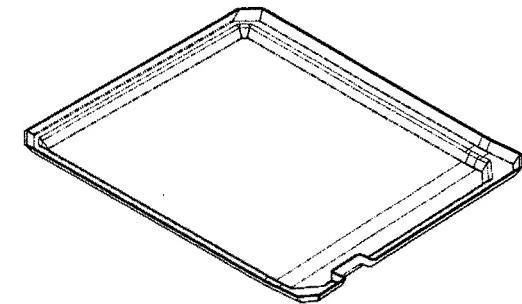
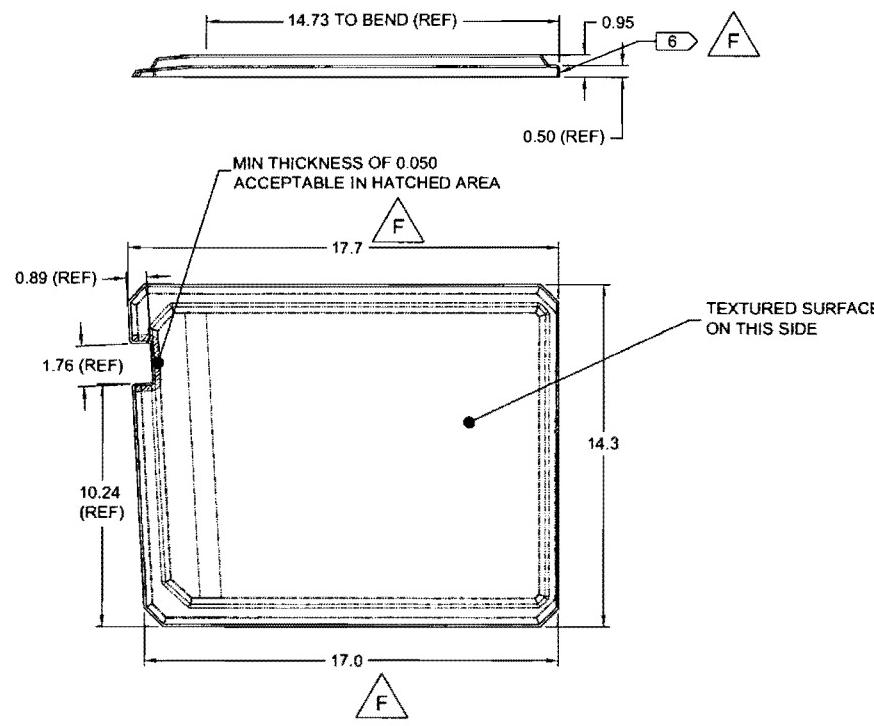
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D



NOTES:

- 1) MATERIAL: -3L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
-3L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 MAX
- 6) IDENTIFICATION: IDENT WITH DART P/N "D3281-3Lxx" AND B/N PER QSI 044 6.4 ALONG PERIMETER OF PART AS SHOWN.
- 7) WEIGHT: D3281-3L02 = 0.87 lb D3281-3L08 = 1.05 lb
- 8) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED

8 7 6 5 4 3 2 1

DESIGN	<i>pp</i>	DART AEROSPACE LTD	
DRAWN	<i>ll</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ll</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>ll</i>	D3281	SHEET 3 OF 4
APPROVED	<i>ll</i>	TITLE	SCALE
DE APPR.	<i>ll</i>	FLOOR PROTECTOR	NTS
DATE	10.09.27	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

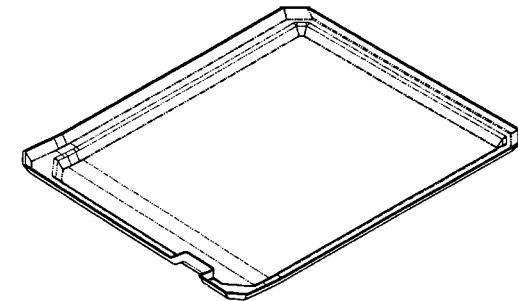
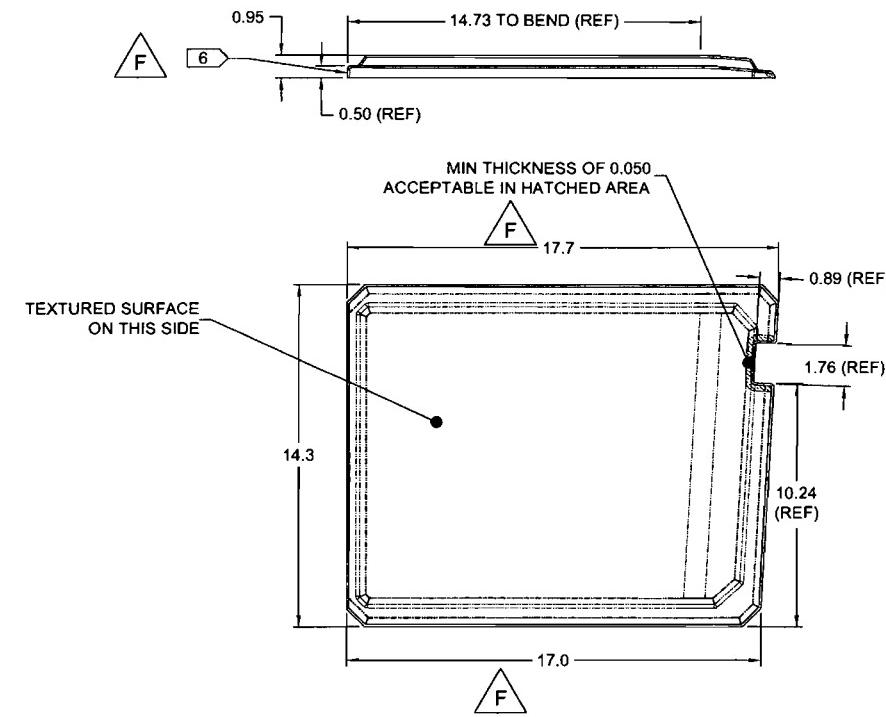
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D



w/o 68658

8 7 6 5 4 3 2 1

D3281-4 NOTES:

- 1) MATERIAL: 4L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
4L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 MAX
- 6) IDENTIFICATION: IDENTIFICATION: IDENT WITH DART P/N "D3281-4Lxx" AND B/N PER QSI 044 6.4 ALONG PERIMETER OF PART AS SHOWN.
- 7) WEIGHT: D3281-4L02 = 0.87 lb D3281-4L08 = 1.05 lb
- 8) THERMOFORM WITH MOLD D3281-T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED

DESIGN	<i>q</i>	DART AEROSPACE LTD	
DRAWN	<i>h</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>h</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>h</i>	D3281	SHEET 4 OF 4
APPROVED	<i>h</i>	TITLE	SCALE
DE APPR.	<i>h</i>	FLOOR PROTECTOR	NTS
DATE	10.09.27	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS ISSUED OR FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

DELETE
in 2010-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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